

D412-664-243	CROSSTUBE ASSEMBLY (412 HI AFT)	DART AEROSPACE LTD	ENGINEERING ORDER	D412-664-243-E-4	SHEET 1 OF 3	SCALE NTS
DRAWN	CP	CHECKED	MFG. APPR.	APPROVED	DE APPR.	
DATE	12.08.21	DATE	DATE	DATE	DATE	

PURPOSE:
REMOVED ABRASION STRIP IN FAVOR OF A THIN LAYER OF PROSEAL 890. THIS
ENGINEERING ORDER SUPERCEDES DEO D412-664-243-E-1

CHANGE:
PARTS LIST IS AMENDED AS FOLLOWS:

Item	Qty	Part Number	Description
	-243		
6	0	D2856-600-1009	ABRASION STRIP

WAS:
6
2
D2856-600-1009
ABRASION STRIP

NOTES 2 AND 14, SHEET 1 ARE AMENDED AS FOLLOWS:

- IS:**
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA)
PAINT OUTSIDE PER DART QSI 005 4.2
AFTER PAINTING, APPLY CLEAR COAT ON HATCHED AREA
 - 14) APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D3189-1
CHAFING SHIELD AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL
PROSEAL D3189-1 CHAFING SHIELD ONTO CROSSTUBE BY APPLYING A THIN COAT OF
PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.
- WAS:**
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
 - 14) INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF
CROSSTUBE PER QSI 035.

PRELIMINARY ISSUE
CP 12/13/23

DRAWING NO.	TITLE	REV. E	DART AEROSPACE LTD	D.E.O. NO.	SHEET NO.	SCALE
D412-664-243	CROSSTUBE ASSEMBLY (412 HI AFT)		ENGINEERING ORDER	D412-664-243-E-4	SHEET 2 OF 3	NTS
DRAWN	CHECKED		MFG. APPR.	APPROVED	DE APPR.	
DATE	DATE	DATE	DATE	DATE	DATE	
12.08.21	12.08.21	12.08.21				

IS:

D3189-1 CHAFING SHIELD (1, INSTALLED OVER PROSEAL 890)
MS21920-28 CLAMP, 2X
2 PL

WAS:

14 16

D2856-600-1009 ABRASION STRIP
D3189-1 CHAFING SHIELD (1, INSTALLED OVER ABRASION STRIP)
MS21920-28 CLAMP, 2X
2 PL

16 14

11.83
TO CLAMP
11.60
TO
CHAFING
SHIELD

D412-664-603
BENT TUBE

CLAMP SPACING
4.00
CHAFING SHIELD, REF
4.38

D3189-1
REF

D412-664-243
ASSEMBLY DETAIL

PRELIMINARY ISSUE

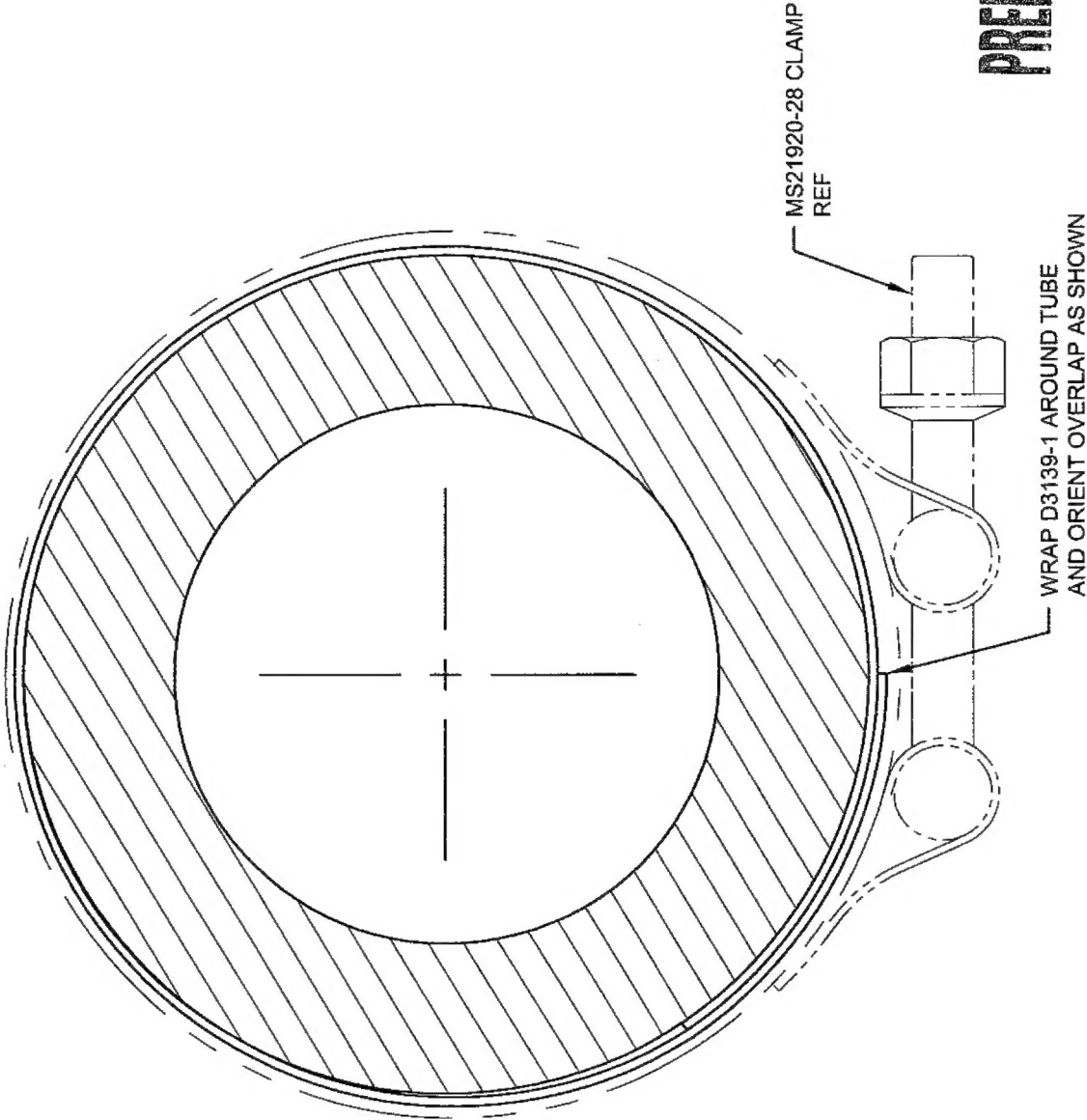
MASK AREA PRIOR TO PAINTING AND
APPLY CLEAR COAT AFTER PAINTING

2

12/10/23

C
SYM

DRAWING NO. D412-664-243	TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	REV. E	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D412-664-243-E-4	SHEET NO. SHEET 3 OF 3	SCALE NTS
DRAWN [Signature]	CHECKED [Signature]	DATE 12.08.21	MFG. APPR.	APPROVED	DATE	DE APPR.	DATE
DATE 12.08.21	DATE 12.08.22	DATE	DATE	DATE	DATE	DATE	DATE



PRELIMINARY ISSUE

Q12/13/23

SECTION A-A
CHAFING SHIELD DETAIL
VIEW ROTATED, NOT TO SCALE